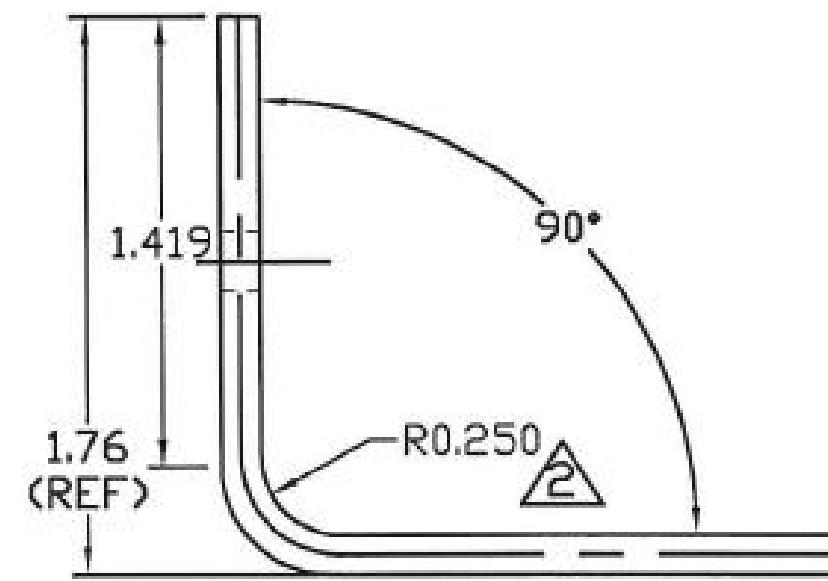
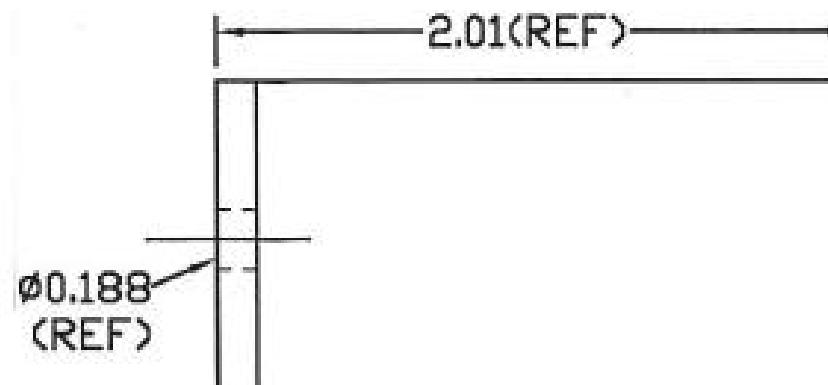


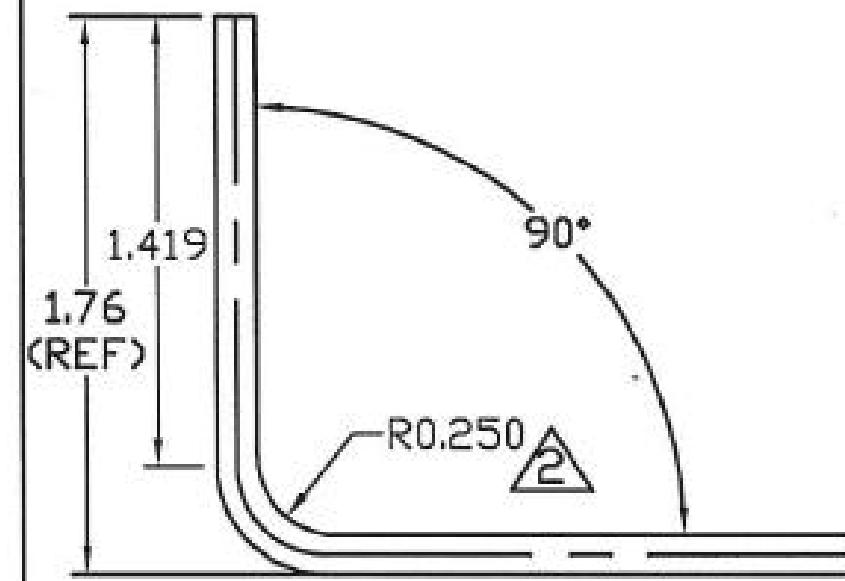
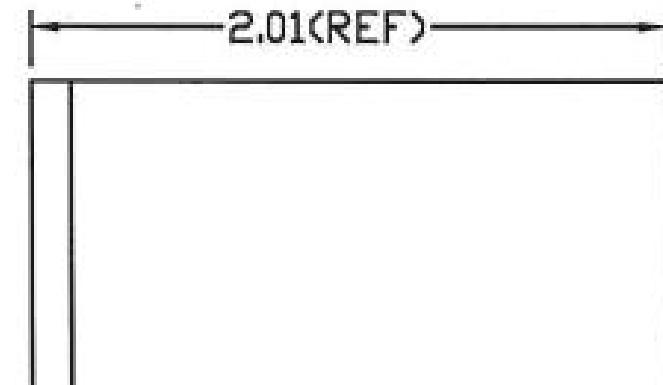
NOTES:

- △ THIS HOLE IN -11/-13 FLAT PATTERN ONLY
 △ INSPECT RADIUS WITH BRIGHT LIGHT AND 10X GLASS AFTER BENDING. PERFORM DYE PENETRANT INSPECTION ON ANY SUSPECT AREAS PER AMS2644, TYPE 2, METHOD A, LEVEL 1 MINIMUM, REF. ASTM E1417 AND MFR'S DATA.
 △ FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE 11, CLASS 2
 ALT FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N

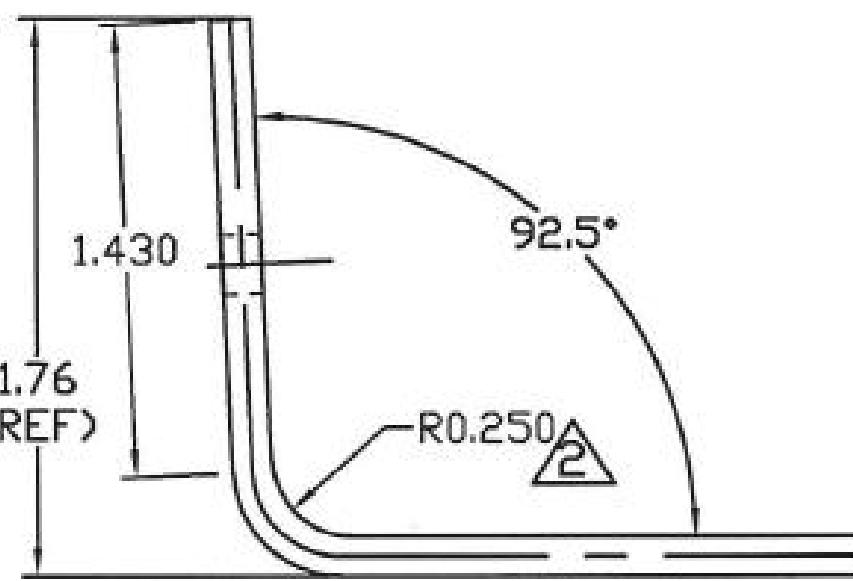
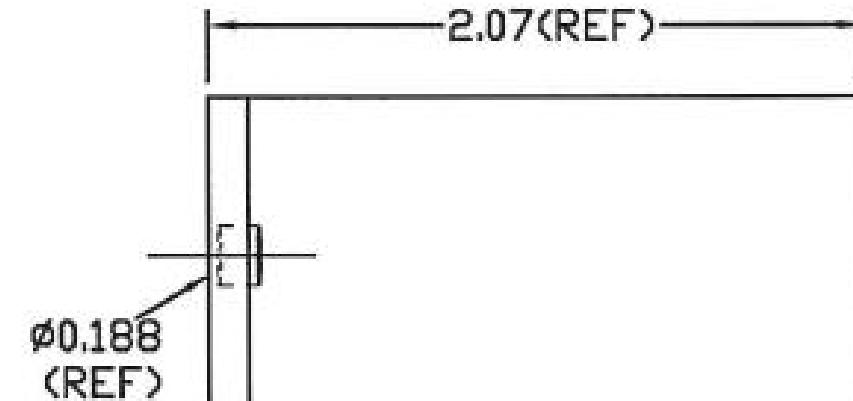
REVISION HISTORY				AUTHOR	CHECKED	APPROVED
DATE	REV	ECO	DESCRIPTION			
9/2/10	A	-	-1,-2,-3,-4 (0.090 THICK) REPLACED BY -11,-12,-13,-14	REB	LS	REB
10/19/10	B	-	ADDED VERTICAL FLANGE DIMS, PENETRANT INSPECTION	REB	LS	REB
7/9/18	A	1	ADDED BEND CHART AND BEND 1 LINE	EW	LS	ZA
10/17/18	A	2	NOTE 2: ADDED INITIAL MAGNIFYING INSPECTION, DYE PENETRANT INSPECTION NOW ONLY ON SUSPECT AREAS	ZA	LS	ZA
9/21/20	B	-	ADDED -21, -22, -23, -24, -25	CMK	LS	CMK



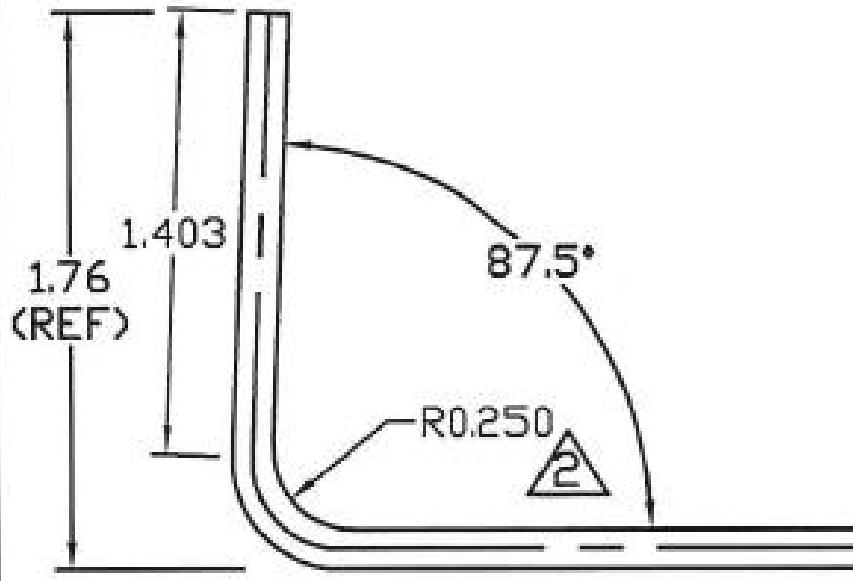
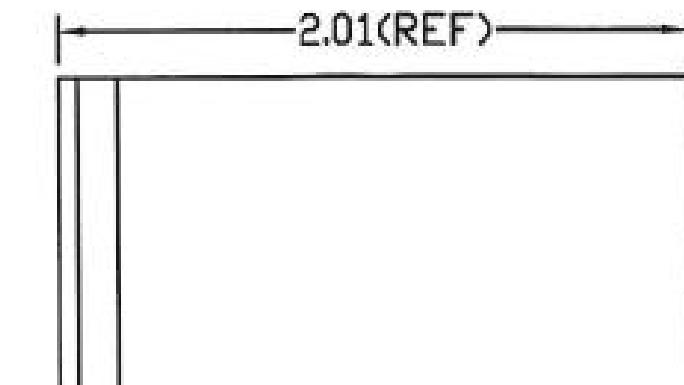
-11 ANGLE
FINISH: △



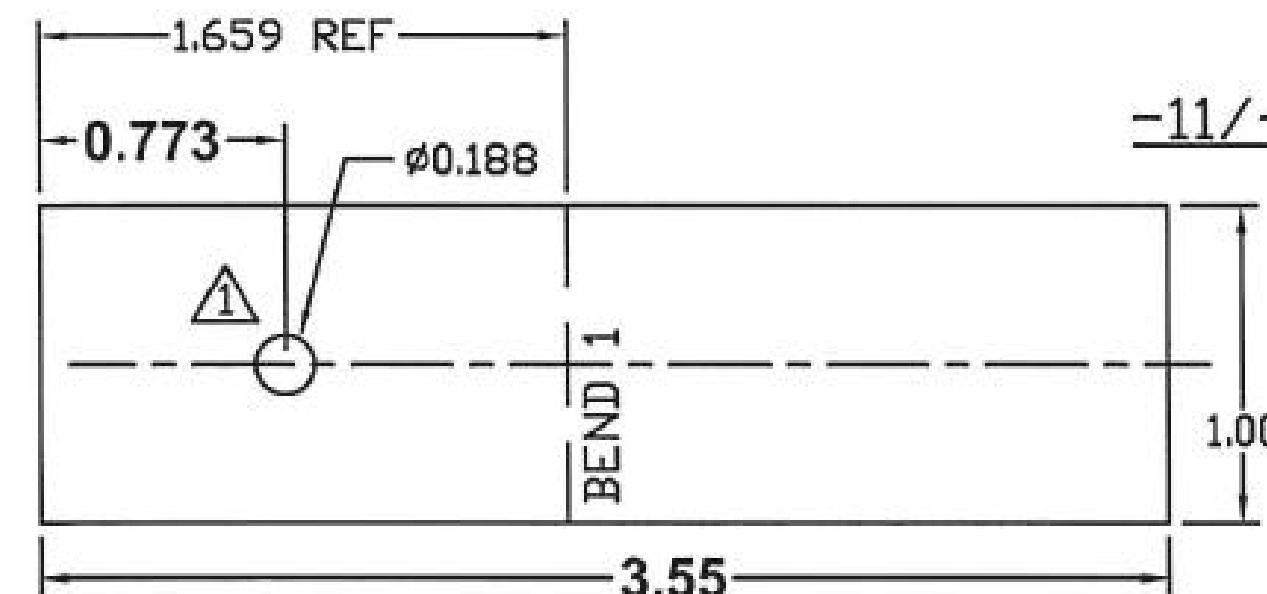
-12 ANGLE
FINISH: △



-13 ANGLE
FINISH: △



-14 ANGLE
FINISH: △



-11/-12/-13/-14 ANGLE (FLAT PATTERN)
MAT'L: 6061-T6, QQ-A-250/11

STOCK: 0.125 SHEET
WEIGHT: 0.04 LB EA. PIECE

BEND CHART	
BEND 1	
PUNCH	#15
DIE	#20
ANGLE	84.5
DIMENSION	1.642

BREAK ALL SHARP EDGES

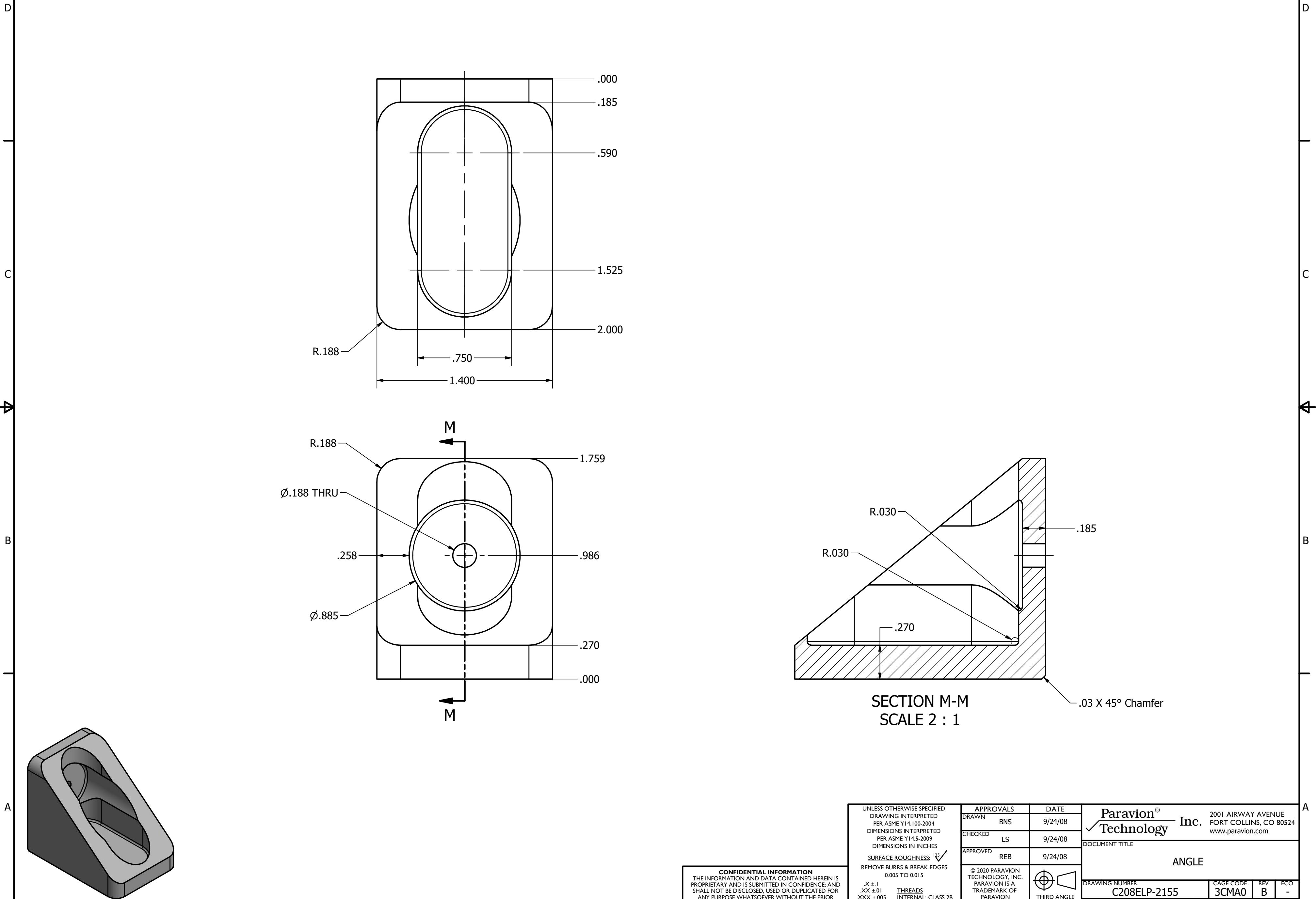
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UNLESS OTHERWISE SPECIFIED	APPROVALS	DATE
DRAWN	BNS	9/24/08
CHECKED	LS	9/24/08
APPROVED	REB	9/24/08
REMOVED BURRS & BREAK EDGES		
0.005 TO 0.015		
X ±1		
XX ±0.1		
XXX ±0.05		
INTERNAL: CLASS 2B		
ANGLES ±1°		
EXTERNAL: CLASS 2A		

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ANGLE	
DRAWING NUMBER	CAGE CODE
C208ELP-2155	3CMA0
REV	B
ECO	-
DO NOT SCALE DRAWING	
SHEET 1 OF 6	

-21 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
 FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
 ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



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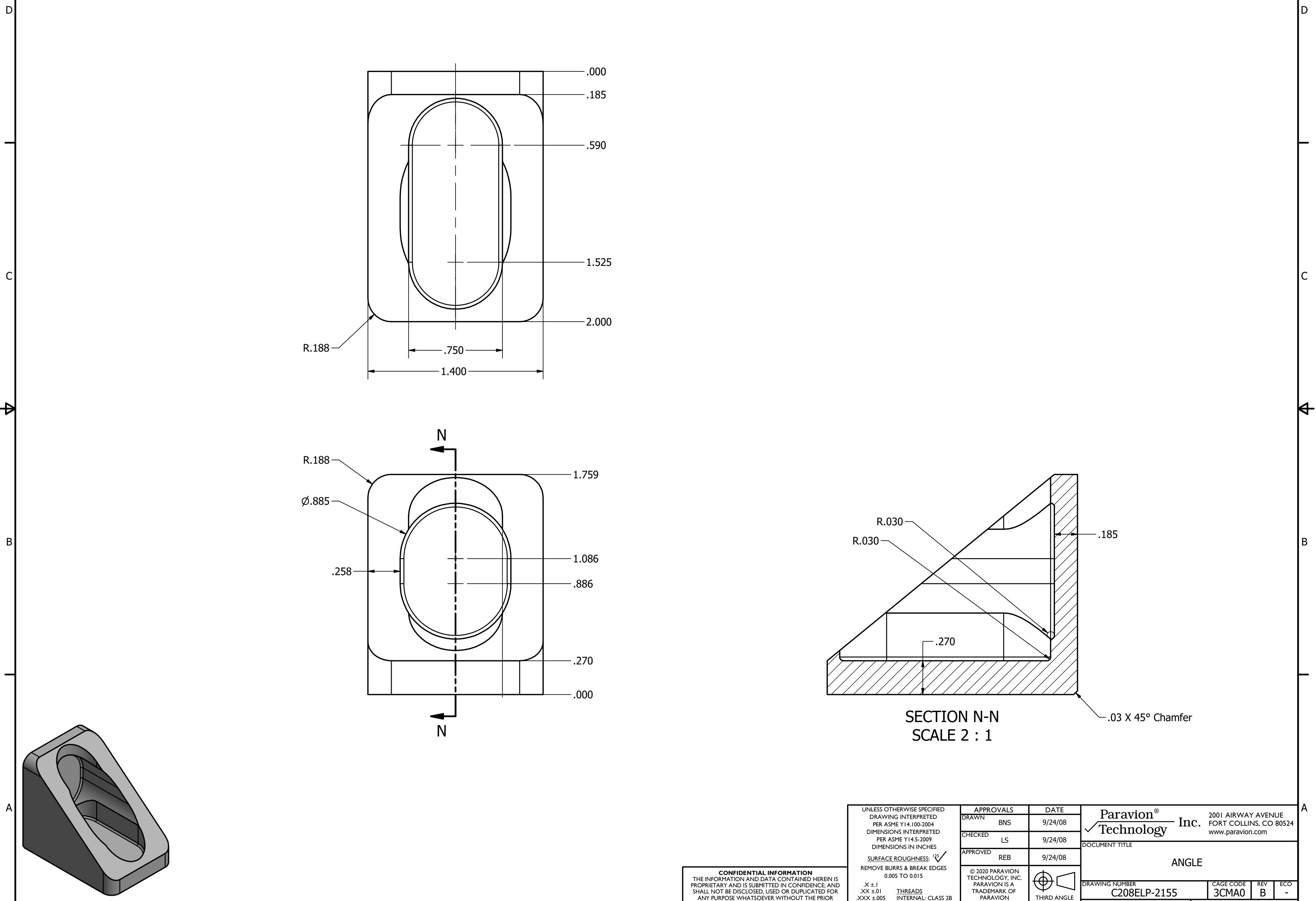
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DRAWN	BNS	9/24/08	
CHECKED	LS	9/24/08	
APPROVED	REB	9/24/08	
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DRAWING NUMBER	C208ELP-2155
CAGE CODE	3CMA0
REV	B
ECO	-

DO NOT SCALE DRAWING SHEET 2 OF 6

-22 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
 FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
 ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



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UNLESS OTHERWISE SPECIFIED		APPROVALS	DATE
DRAWN	BNS	9/24/08	
CHECKED	LS	9/24/08	
APPROVED	REB	9/24/08	
SURFACE ROUGHNESS: $\frac{1}{16}$	✓		
REMOVE BURRS & BREAK EDGES		0.005 TO 0.015	
X ± .1			
XX ± .01		THREADS	
XXX ± .005		INTERNAL: CLASS 2B	
		EXTERNAL: CLASS 2A	

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	DOCUMENT TITLE	ANGLE
DRAWING NUMBER	C208ELP-2155	CAGE CODE 3CMA0
REV	B	ECO
DO NOT SCALE DRAWING		Sheet 3 of 6

-23 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
 FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
 ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2

D

D

C

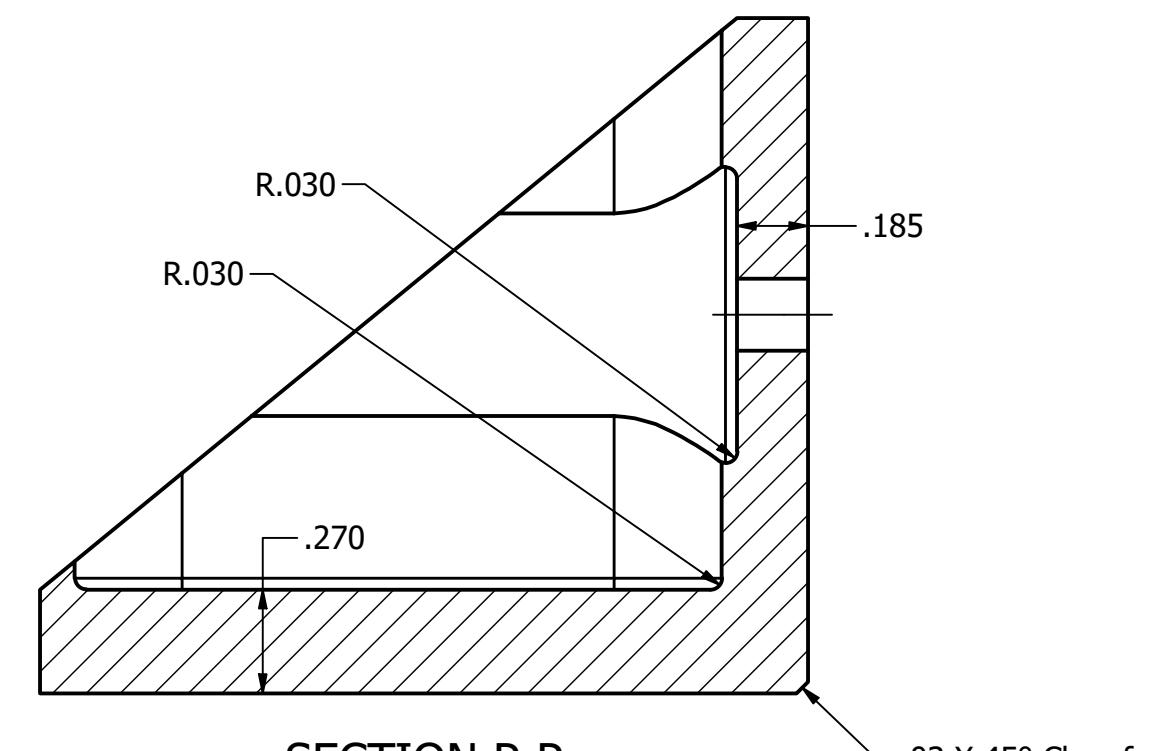
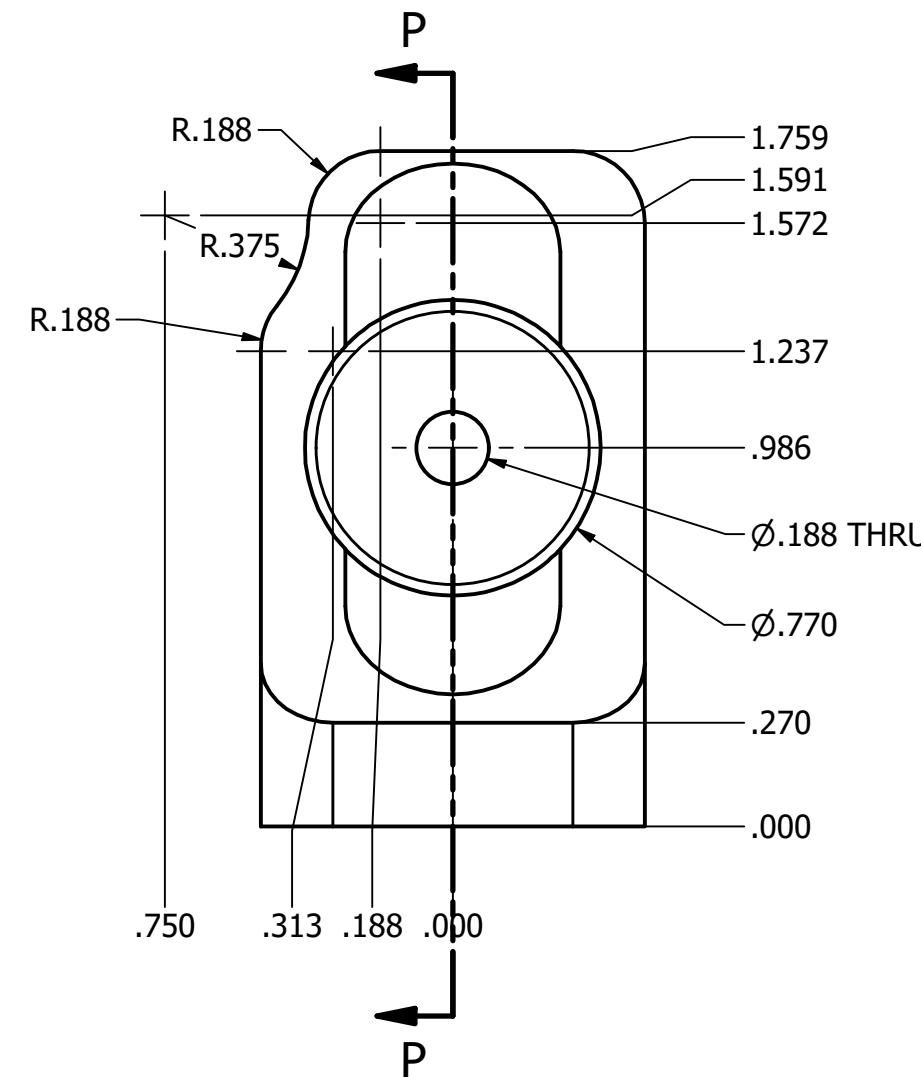
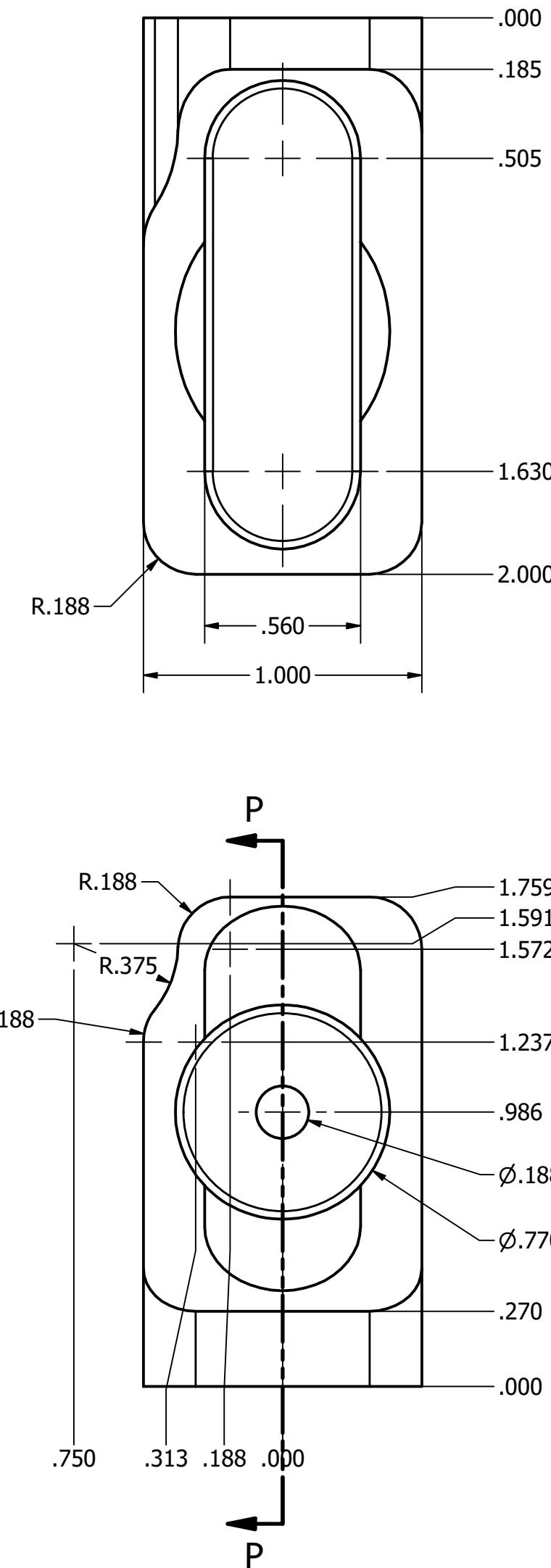
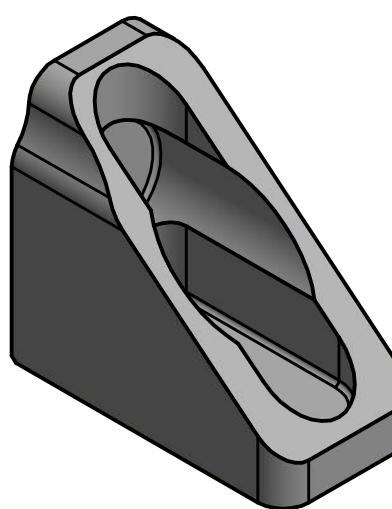
C

B

B

A

A



SECTION P-P
SCALE 2 : 1

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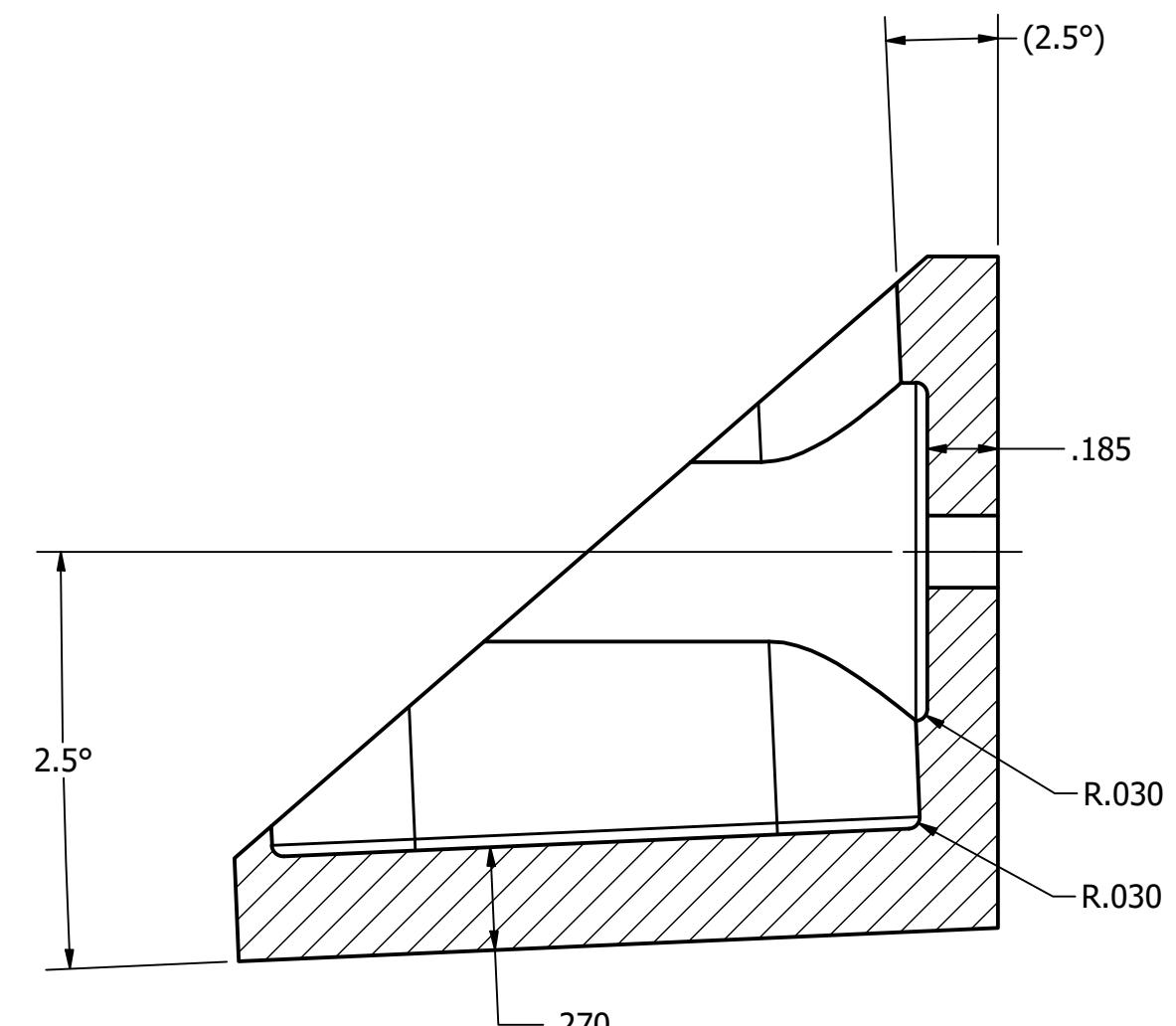
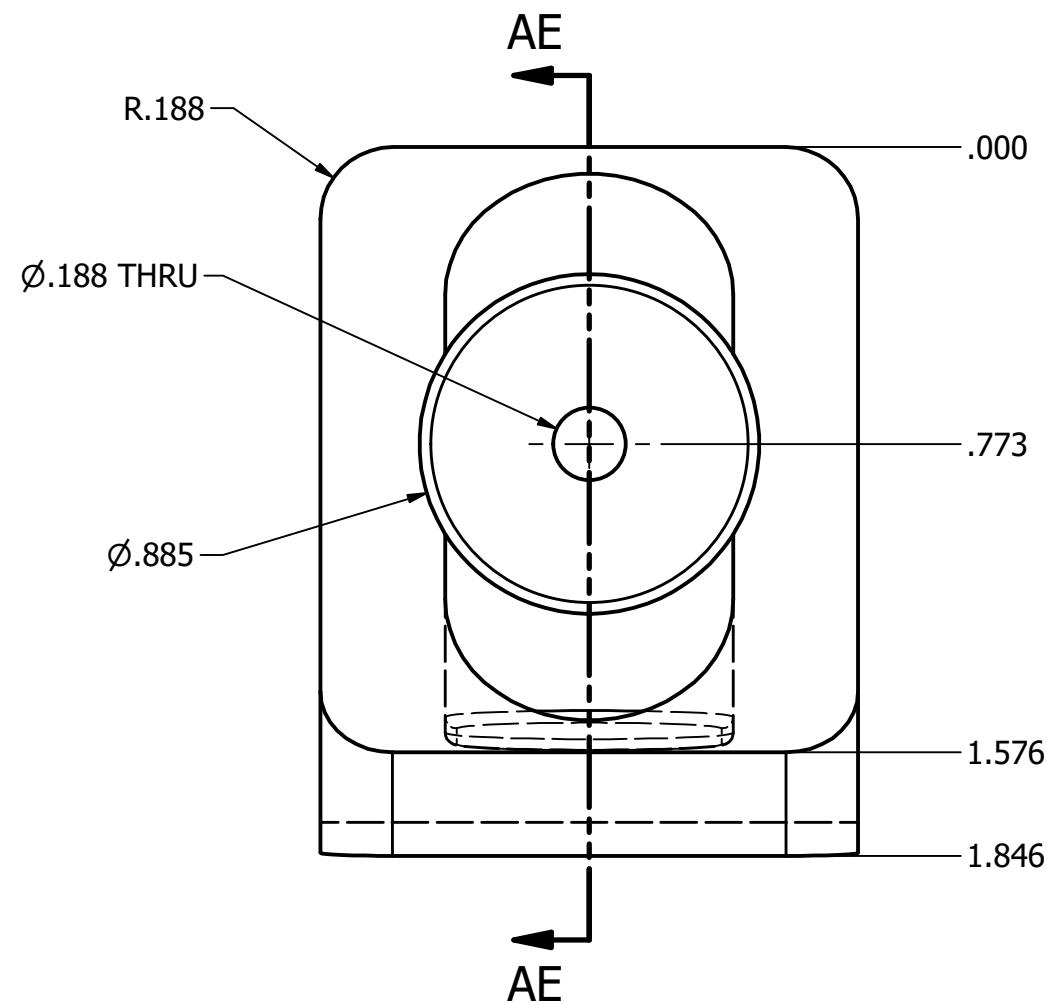
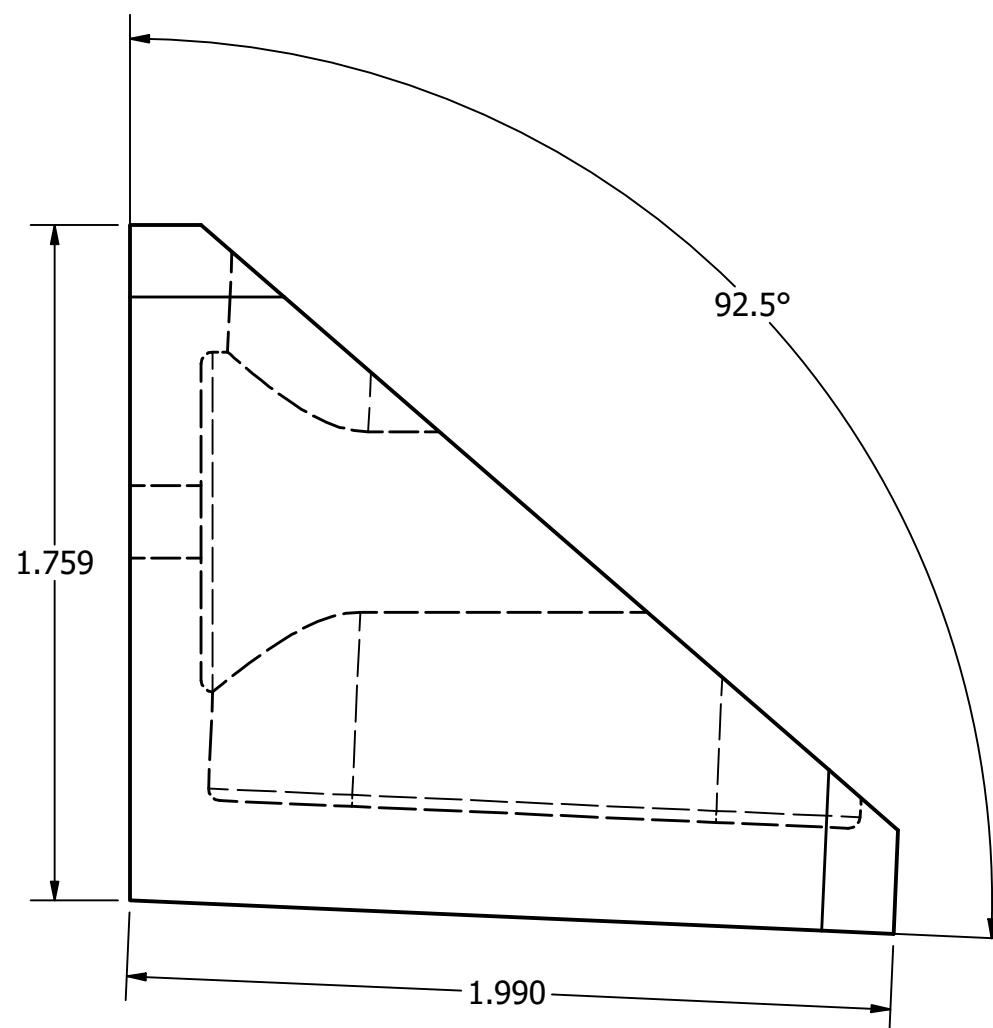
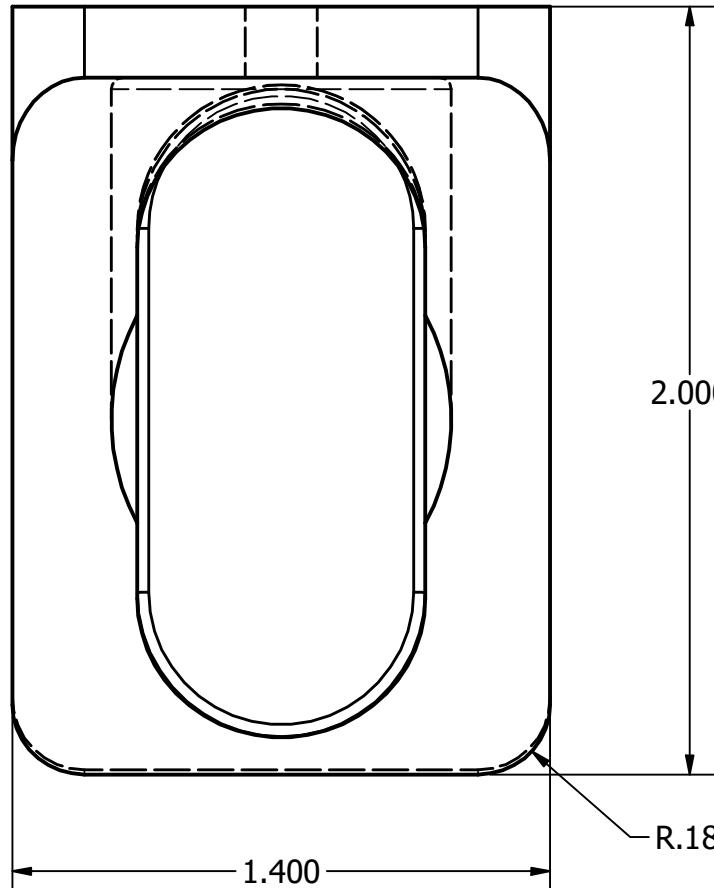
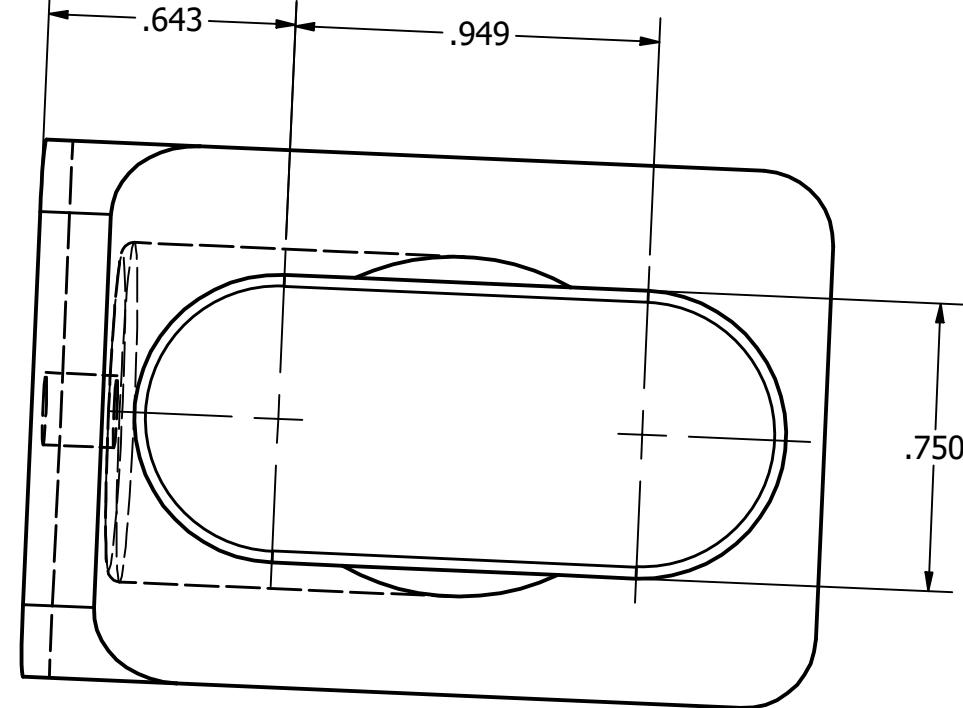
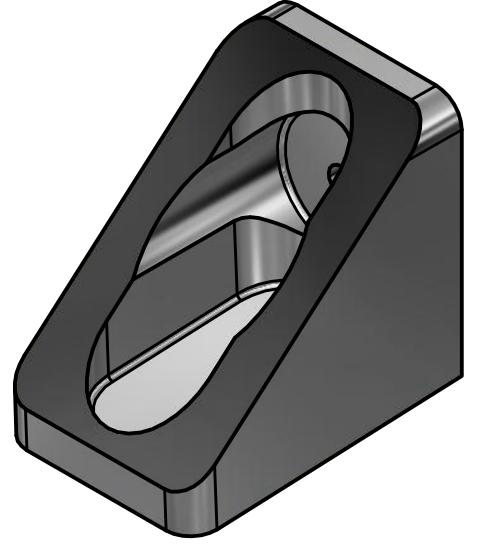
UNLESS OTHERWISE SPECIFIED		
DRAWN	BNS	9/24/08
DIMENSIONS INTERPRETED PER ASME Y14.5-2009	CHECKED	9/24/08
SURFACE ROUGHNESS: $\frac{1}{16}$	APPROVED	9/24/08
REMOVE BURRS & BREAK EDGES 0.005 TO 0.015	© 2020 PARAVION TECHNOLOGY, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY, INC.	
X ± .01 XX ± .01 XXX ± .005	THREADS INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	
ANGLES ± 1°		

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-24 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



SECTION AE-AE
SCALE 2 : 1

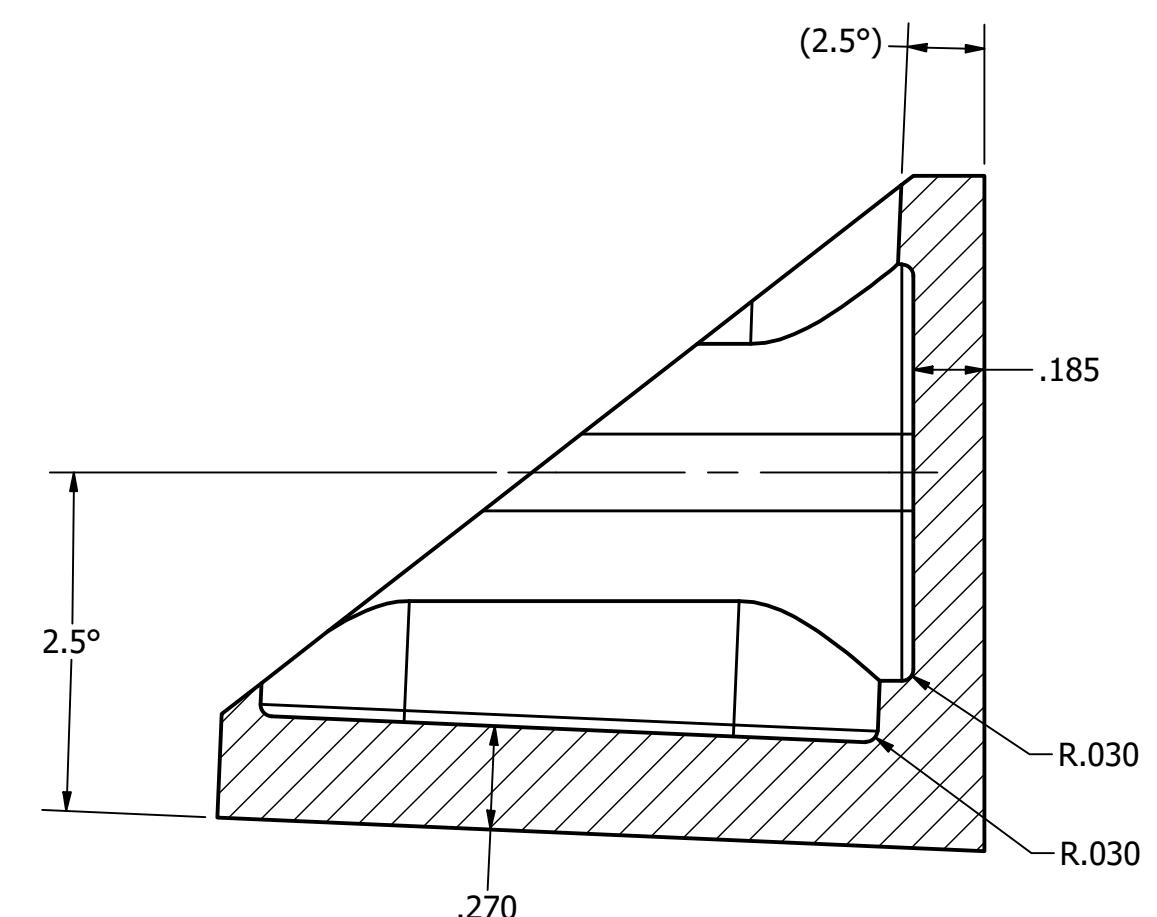
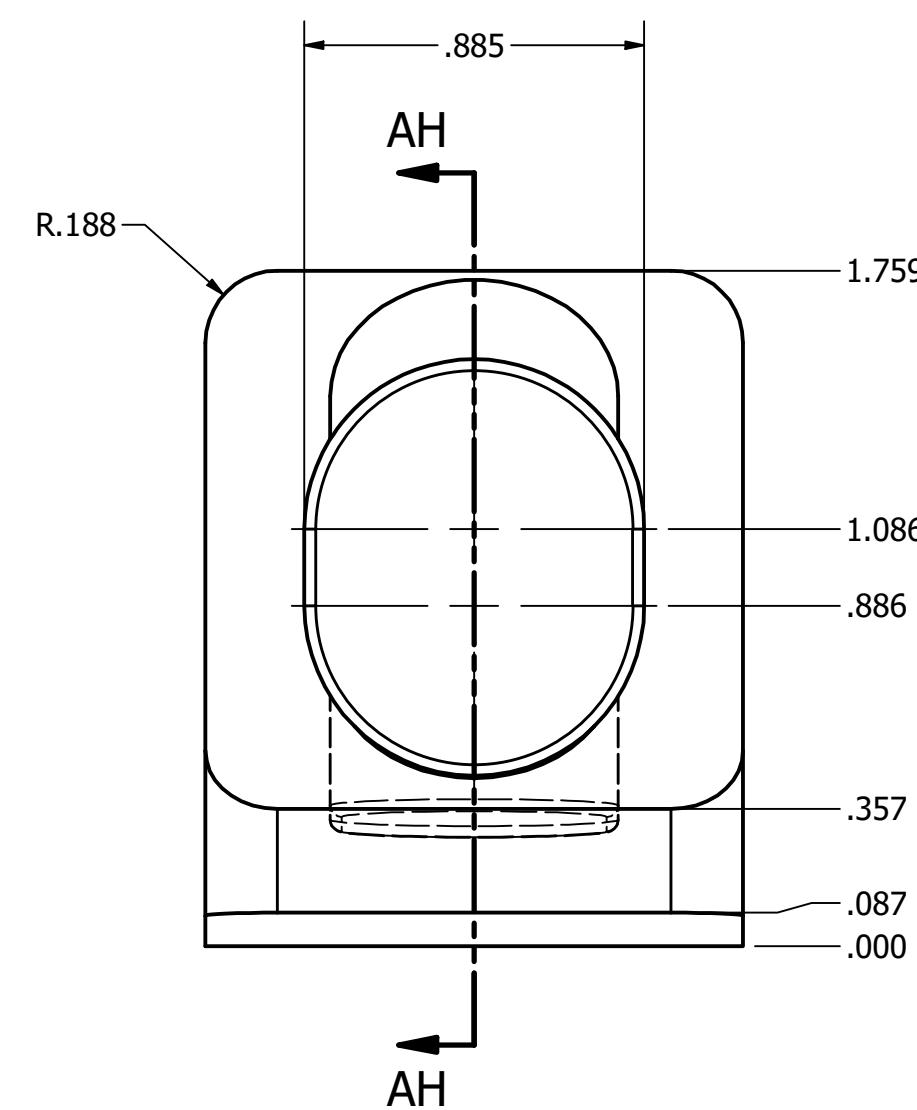
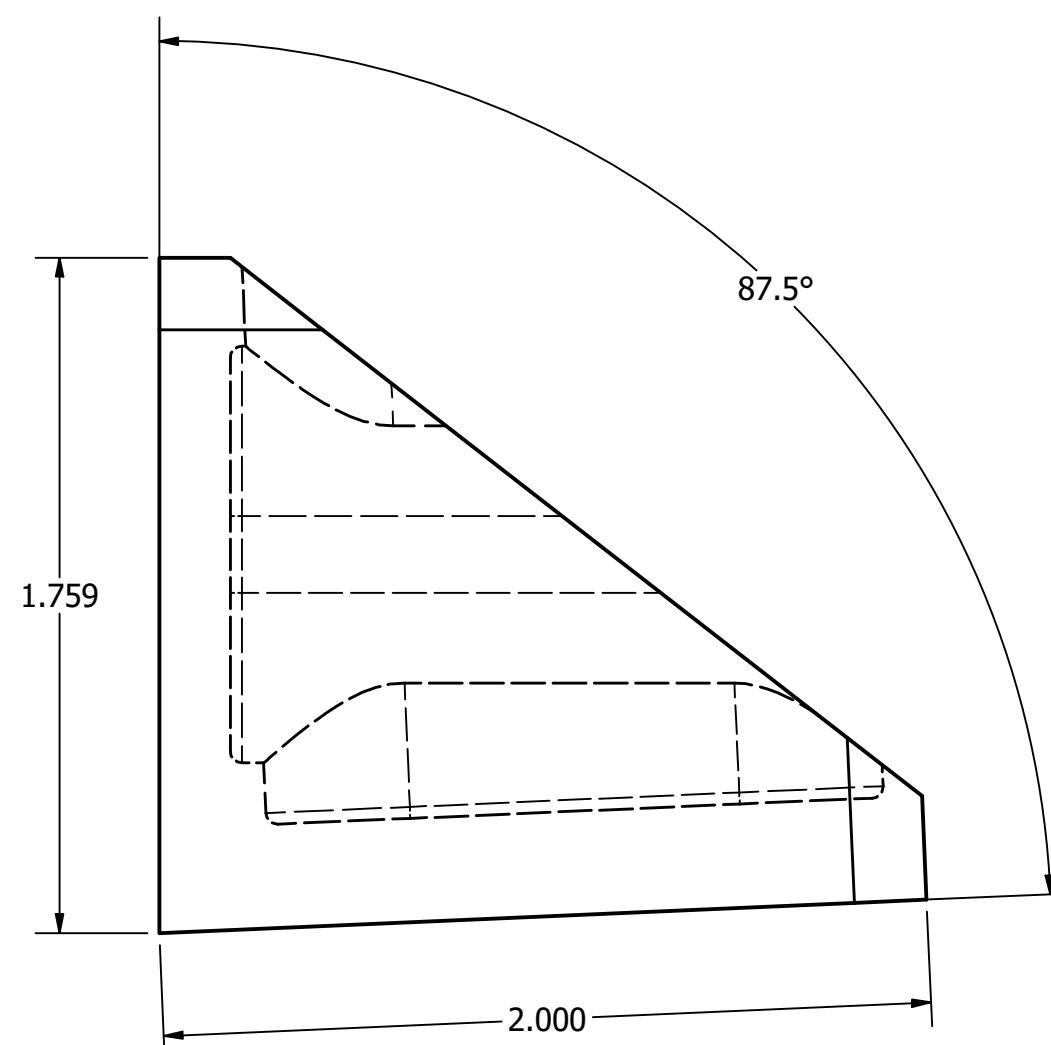
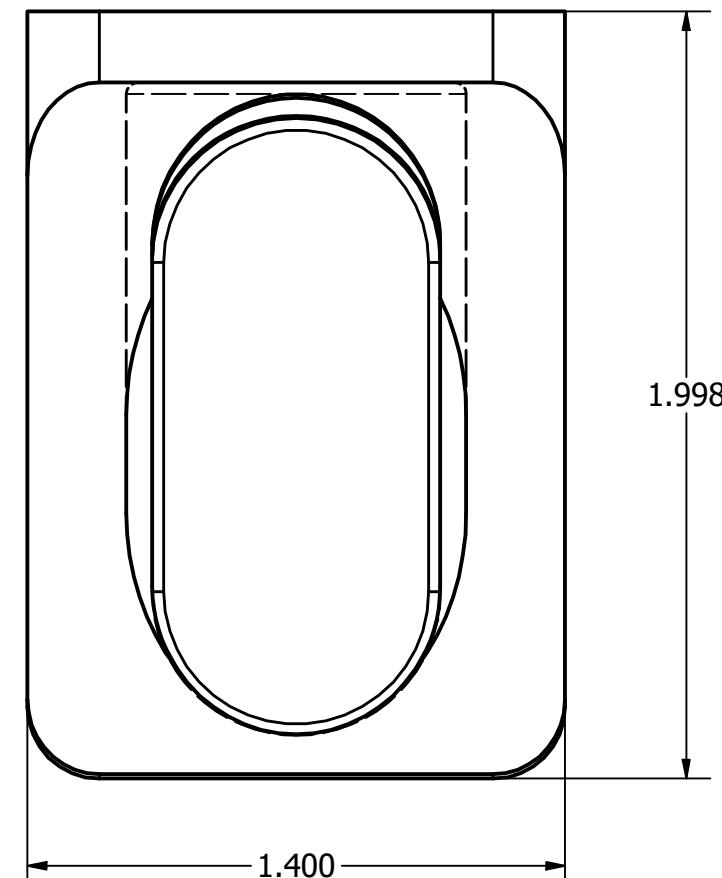
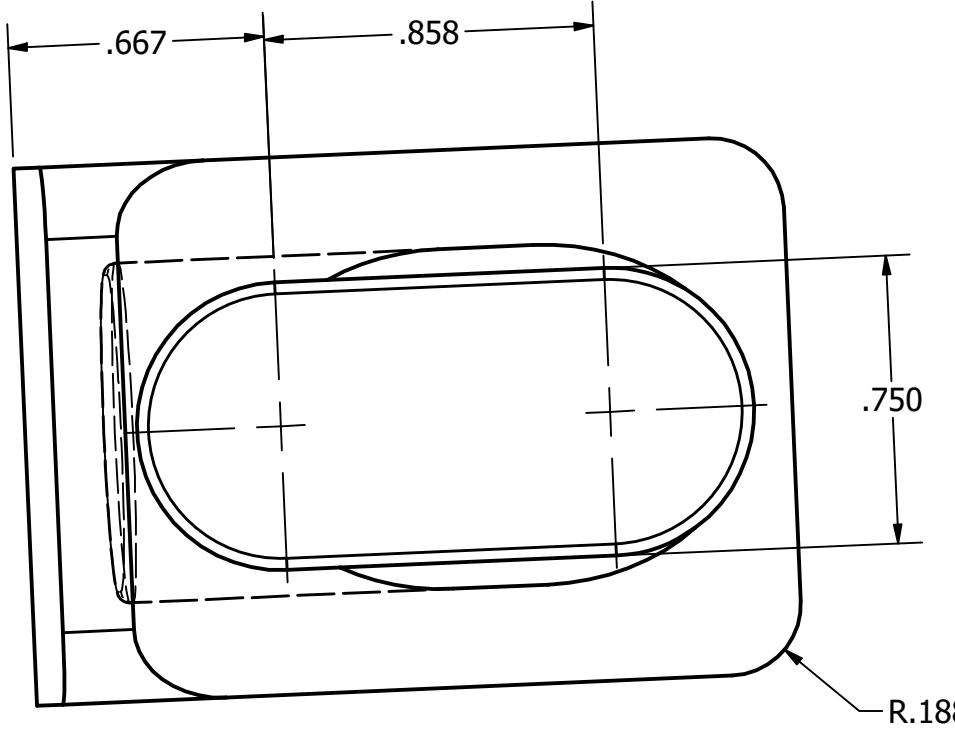
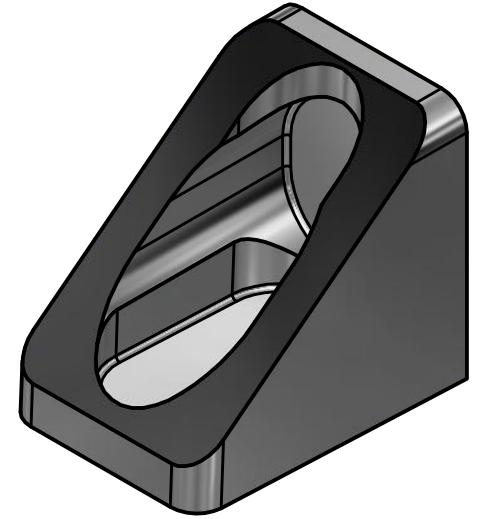
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UNLESS OTHERWISE SPECIFIED	
DRAWN	BNS
CHECKED	LS
APPROVED	REB
SURFACE ROUGHNESS: $\frac{1}{16}$	
REMOVE BURRS & BREAK EDGES	
0.005 TO 0.015	
X ± .1	THREADS
XXX ± .005	INTERNAL: CLASS 2B
	EXTERNAL: CLASS 2A

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ECO	-

-25 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



SECTION AH-AH
SCALE 2 : 1

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UNLESS OTHERWISE SPECIFIED	
DRAWN	BNS
DIMENSIONS	PER ASME Y14.100-2004
INTERPRETED	PER ASME Y14.5-2009
SURFACE ROUGHNESS:	0.005 TO 0.015
REMOVED BURRS & BREAK EDGES	✓
X ± .1	THREADS
XXX ± .005	INTERNAL: CLASS 2B
ANGLES ± 1°	EXTERNAL: CLASS 2A

APPROVALS	DATE	Paravion® Technology Inc.
DRAWN	BNS	2001 AIRWAY AVENUE FORT COLLINS, CO 80524 www.paravion.com
CHECKED	LS	DOCUMENT TITLE
APPROVED	REB	ANGLE
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		SHEET 6 OF 6